

Date: Monday, 02/03/2009 11:23:28 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : MIRROR BRACKET

Job Number : 46161

Estimate Number : 10142

P.O. Number :

Part Number : D2161204 *BK*

This Issue : 02/03/2009 S.O. No. :

Drawing Number : D2161

Prsht Rev. : NC

Project Number : N/A

First Issue : / / Type : SMALL / MED FAB

Drawing Revision : B2

Previous Run : 45877A

Material :

Due Date : 20/03/2009 Qty: 4 Um: Each

Written By :

Checked &amp; Approved By :

*JLD 09.03.02*

Comment :

: Est Rev:A New Issue 05-11-01 JLM

Est Rev B: QC9, QC5 added at steps 5,6 KJ Verified by: EC

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

46161A

MIRROR BRACKET



Comment: Sub-Component MIRROR BRACKET

*B 47417 = 3x*1 x D2013-5 Batch *B36919A = 1x**sp 09.05.21*

2.0

46161B

MIRROR BRACKET



Comment: Sub-Component MIRROR BRACKET

1 x D2013-6 Batch *B 46161 B (4x)*

3.0

46161C

ARM



Comment: Sub-Component ARM

1 x D2037-101 Batch *B 44122 A03 4x**sp 09.05.21*

4.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble on Jig DT8065 as per Dwg D2161

2-Weld as per Dwg D2161 Identify as D2161-204

*sp 09.05.21 (AK)*

5.0

QC9

VISUAL WELDING INSPECTION

*(4)*

Comment: VISUAL WELDING INSPECTION

*sp 09.05.21*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: MIRROR BRACKET

Job Number: 46161

Part Number: D2161204

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*Solder 1 (74)*



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



*X11 109091*



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

*8:00 AM*

OVEN TEMPERATURE:

*320°F*

FINISH TIME:

*8:30 AM*

*01-05-25 (4)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*F2 09/05/25 (4)*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/05/27 (4)*

Job Completion



*MF 09-05-27*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

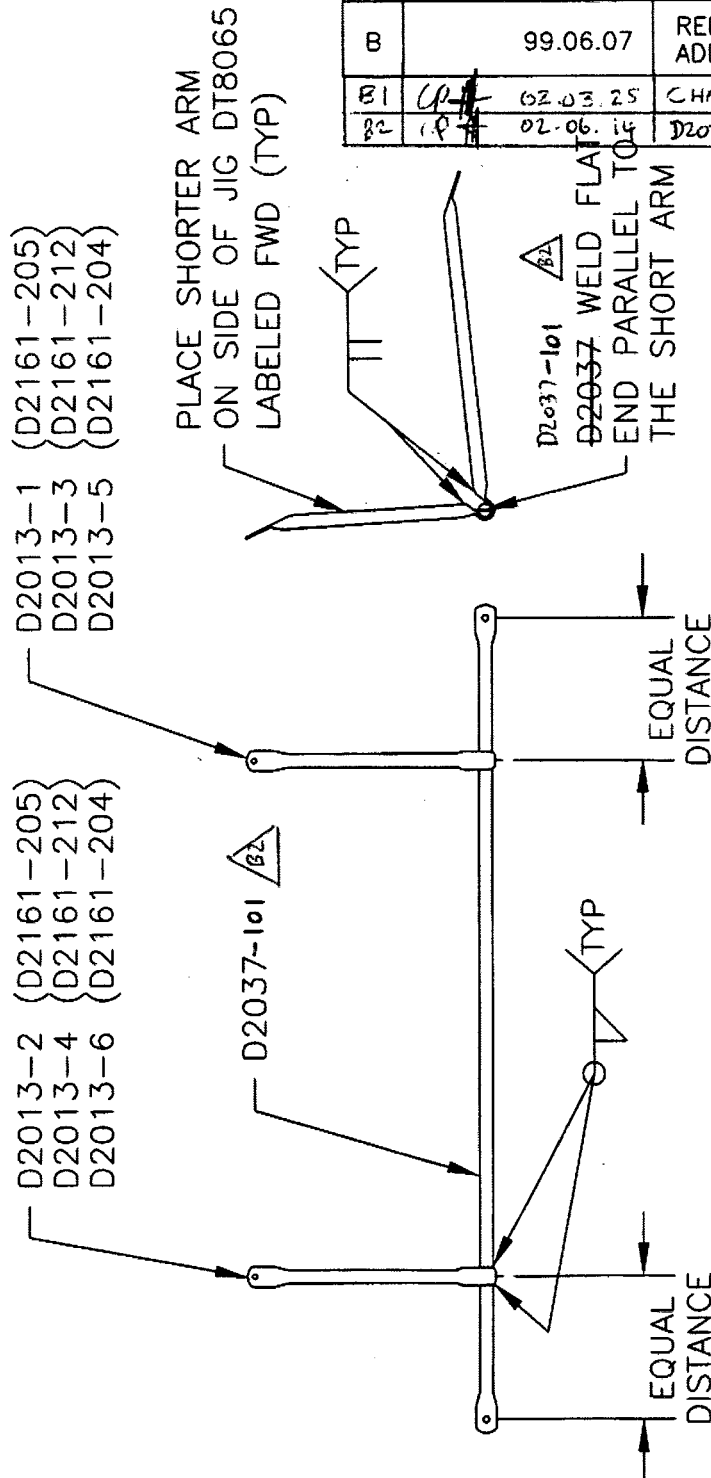
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|         |          |  |                |   |              |
|---------|----------|--|----------------|---|--------------|
| DESIGN  | JB       | DRAWN BY   | RF             | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |              |
| CHECKED | ZE       | APPROVED   | [Signature]    | DRAWING NO.                                       | REV. B       |
| DATE    | 99.06.07 | TITLE  | MIRROR BRACKET | D2161   | SHEET 1 OF 1 |
| A       | 93.04.29 | NEW ISSUE  |                |   | SCALE        |
| B       | 99.06.07 | REDRAWN FOR CLARITY<br>ADDED -204/-205/-212 DESIGNATIONS |                |   | NTS          |
| B1      | 02.03.25 | CHANGE FINISH  |                |   |              |
| B2      | 02.06.14 | D2037-101 WELD FLAT                                      |                |   |              |

RELEASED  
KE 99.06.10



DETAIL OF D2161-204  
DETAIL OF D2161-205  
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY  
USING JIG DT8065

POWDER COAT ASSEMBLY BLACK  
GRINKE (4.3.5.3) PER DART QSI-005 4.3-  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER  
DART QSI-005 4.3

SHIP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

No. 2161